

Work Order ID 73699



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Tuesday, September 13, 2011 12:37:42 PM

Item ID:	D3009-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Cup				Stop	
Start Date:	9/13/2011	Start Qty:	100.00			
Required Date:	9/20/2011	Req'd Qty:	100.00			
Reference:						

Approvals:	Process Plan:	<u>ME</u>	Date:	<u>11-09-13</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3009	Rev B

100		0.00							
	Hardinge CNC LATHE SMALL								<u>100</u>
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FAI30 & DWG D3009								
	FOLIO REV: <u>REN/A</u>								
	DWG REV: <u>B</u>								
	2-DEBURR AS REQUIRED								
			<u>419/14</u>						
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								<u>100</u>
QC	Memo	0.00							
Quality Control									
			<u>419/14</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:					Stop	
Item Name:	Cup					
Start Date:	9/13/2011	Start Qty:	100.00		Cust Item ID:	
Required Date:	9/20/2011	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00		2L 11-09-16					
QC Quality Control	Memo	0.00							
130 	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Q 11-9-19

11/9/19

ME 11-09-19

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Picklist Print

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Work Order ID: 73699

Parent Item: D3009-3

Parent Item Name: Cup



Start Date: 9/13/2011

Required Date: 9/20/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP A ☐ 07.12.18 ☐ new issue EC ☐
IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000 304 round bar 1.00		Purchased	No			110	f	57.9500	0.0479	5.042105			

Location

Loc Qty

Loc Code

MAT029

57.95

109508

12.5

109541

0.08

113457

45.37

SL 10/9/15

4 feet

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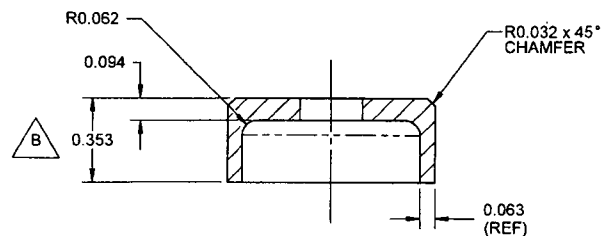
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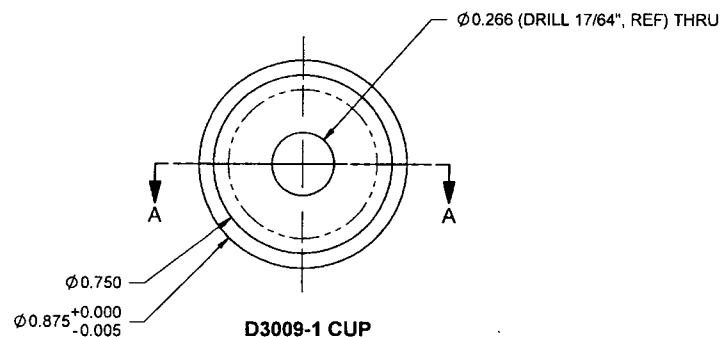
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SECTION A-A



D3009-1 CUP

NOTES:

- 1) MATERIAL: AISI 1018-1025 ROUND BAR
(REF DART SPEC M1018-R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

73699

RELEASED
08-01-07

B	REDRAW/REFORMAT DWG. D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2)	CP	07.12.12
A	NEW ISSUE	RF	01.03.23
REV.	DESCRIPTION	BY	DATE
DESIGN	921	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3009 TITLE CUP SCALE 2:1 COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	921		
CHECKED	B		
MFG. APPR.	B		
APPROVED	B		
DE APPR.	B	REV. B SHEET 1 OF 2	
DATE	07.12.12		

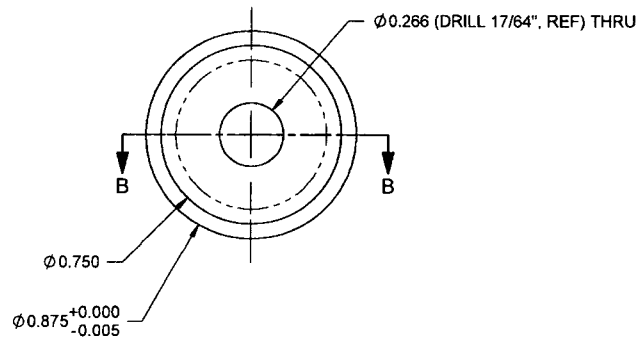
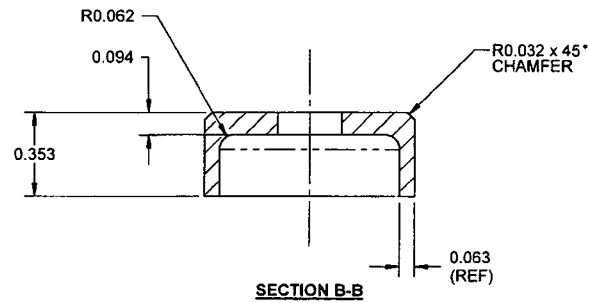
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D3009-3 CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	921	DART AEROSPACE LTD	
DRAWN	921	HAWKESBURY, ONTARIO, CANADA	
CHECKED	921	DRAWING NO.	REV. B
MFG. APPR.	921	D3009	SHEET 2 OF 2
APPROVED	921	TITLE	SCALE
DE APPR.	921	CUP	2:1
DATE	07.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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RELEASE
03-01-07-10

#73699

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